

Work Order ID 129779

February-23-15 10:21:31 AM

129779

Page 1

Item ID: D4709-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spring Clip
 Start Date: 2/23/15 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 2/23/15 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-02-24 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D4709	B
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110		0.00
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110

Waterjet

FLOW CNC Waterjet

301 22GA

FULL HARD.

Memo

1-Cut as per Dwg B
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

0.00

6 8 JM 15-3-10

120	QC2- Inspect parts off machine FAI/FAIB	0.00
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120

QC

Quality Control

Memo

0.00

6 8 JM 15-3-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>(6)</u>			DAS 38 9-89 MAR 10 2015
140 *140* Brake NC Brake NC	Form as per dwg Memo	0.00 0.00			DAS 30 9-89	<u>6</u>			APR 15 2015
150 *150* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>(6)</u>			DAS 38 9-89 APR 17 2015

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>St 123</u>	0.00				<u>6</u>			
160									
Packaging	Memo	0.00							
Packaging									
									APR 20 2015
									DAS 6 9-89
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

MCJ 1504-21
MCJ 1504-21

DQA: _____ Date: _____



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FAULT CATEGORY

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Picklist Print

February-23-15 10:21:30 AM

Page 1

Work Order ID: 129779

129779

Parent Item: D4709-1

D4709-1

Parent Item Name: Spring Clip

Start Date: 2/23/15

Required Date: 2/23/15

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A 12.09.11 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M301S22GA		Purchased		No			sf	1.5000					
M301S22GA										**			
301 SS Sheet - Full hard													

Location

Loc Qty

Loc Code

MAT020

1.5

M125735

1.5

125735

25

JM15-3-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

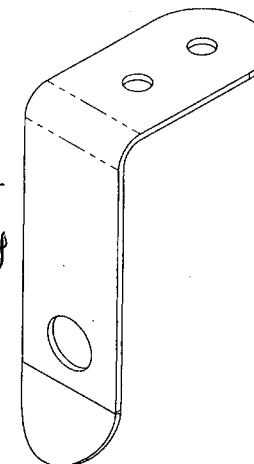
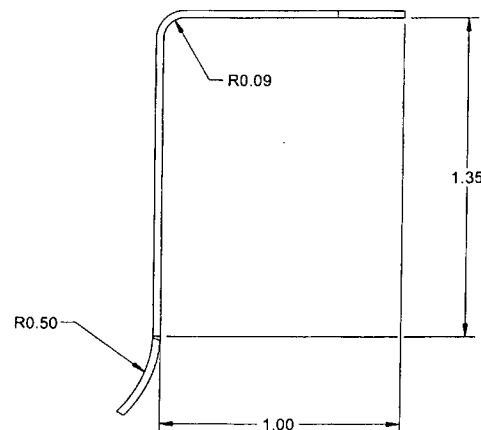
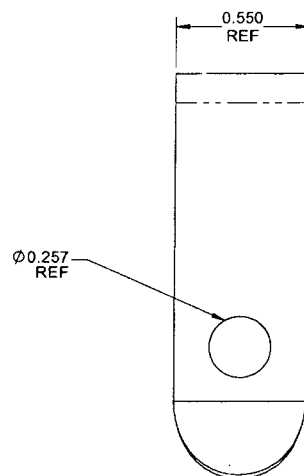
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FAULT CATEGORY

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D4709-1 SPRING CLIP

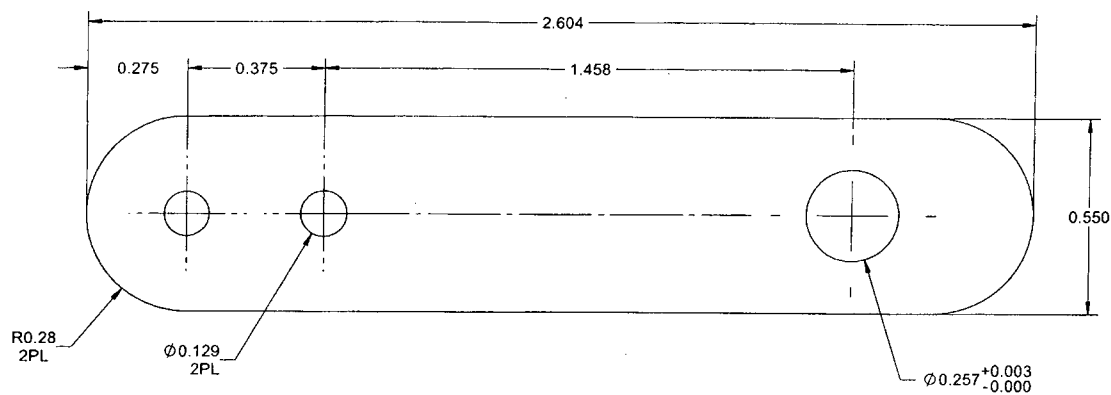
NOTES:

- 1) MATERIAL: MAKE FROM D4709-1F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4709-1" AND B/N "BXXXXX" PER QSI 044 6.7
- 7) WEIGHT: 0.01 lbs

B	MATERIAL NOW AISI 301 STAINLESS STEEL (FULL HARD CONDITION), THICKNESS NOW 0.031 THK (C2-2)	AP	12.11.22
A	NEW ISSUE	RP	12.09.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.		D4709	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPRING CLIP	NTS
DATE	12.11.22	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
R 2012-12-06
mp

UNCLAS
S
NO. 129779 MJS
15-02-24



D4709-1F SPRING CLIP

RELEASED
R 2012-12-06
WP

NOTES:

- 1) MATERIAL: AISI 301 STAINLESS STEEL SHEET PER AMS 5519 OR ASTM 686 (FULL HARD) $\triangle B$
REF DART SPEC M301S22GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AP	DRAWING NO.	REV. B
MFG. APPR.		D4709	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		SPRING CLIP	NTS
DATE	12.11.22	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS COVENANT THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	